



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	22627
<b>Description:</b> Custom W/O collective for AS355	<b>Part Number:</b>	<b>D3400-041</b>
	<b>Keyed:</b>	<input checked="" type="checkbox"/> Alike <input type="checkbox"/> Unalike
<b>Dwg:</b> D3400 Rev. A & IIN-D350-740 page 6		
<b>Ref:</b> N/A NCR - 838		<b>Page 1 of 1</b>

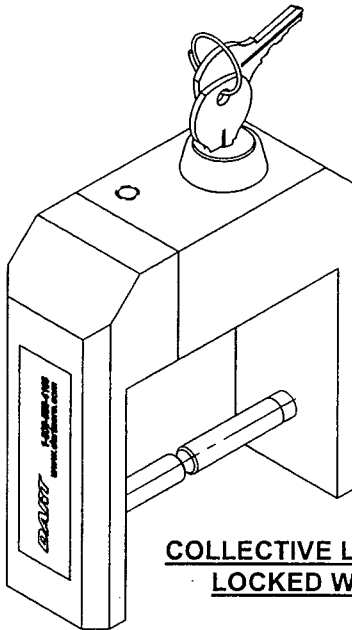
Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	JA	05.03.07	1
2	SALES	Remove D3372-041 Collective Disabling Kits from finished inventory. Qty Part Number Description Batch 1 D3372-041 Collective Disabling Kit B22167B	RF PEK LL	05.03.07	1
3	GA	Open box and remove D3369-041 Battery Lock Assembly. Disassemble Cam mechanism on D3373-1 Lock assembly.	2	05.03.07	1
4	CM	Rework collective D3400-1 & D3400-5 as per Dwg D3400 Deburr.	JA	05.03.07	1
5	GA	Assemble Cam mechanism as per Dwg D3400. Using the key, ensure disconnect/lock works properly, and the key can be removed in the lock/open position.	2	05.03.07	1
6	QC5	Inspect work to Step 5	RF	05.03.07	1
7	WS	Weld D3372-5 lock shaft with thick square washer. Using the key, ensure disconnect/lock works properly, and the key can be removed in the lock/open position as per Dwg D3400. <b>Identify as D3400-051</b>	PD	05.03.07	1
8	QC9 / 5	Inspect work to Step 7	RF	05.03.07	1
9	GA	Assemble D3384-043 to D3400-051 using 1/4"-20 socket head cap screw and washers as per Dwg IIN-D350-740. <b>Pick:</b> Qty Part Number Description Batch 2 AN960-416 Washer M5519 1 HX-81 1/4"-20 SHCS 3/8" long M16971 <b>Identify as D3400-041 &amp; attach keys</b> <b>Record the Key Number</b>	2	05.03.07	1
10	QC5	Inspect work to Step 9	RF	05.03.07	1
11	ST	Repack D3400-041. Ensure batch and <b>key number</b> matches with the box. Attach D2428-1 Batch B22554	CL	05/03/07	1
12	SALES	Return to finished inventory	RF	05.03.07	1
13	AC	Cost / part: 57.23	SUC	05.03.10	1
14	DC	Close W/O 57.23 Inspect Level 21	JA	05.03.18	1

(Note: Attach a copy of Custom W/O to each of the W/O's listed in Step 2 above)

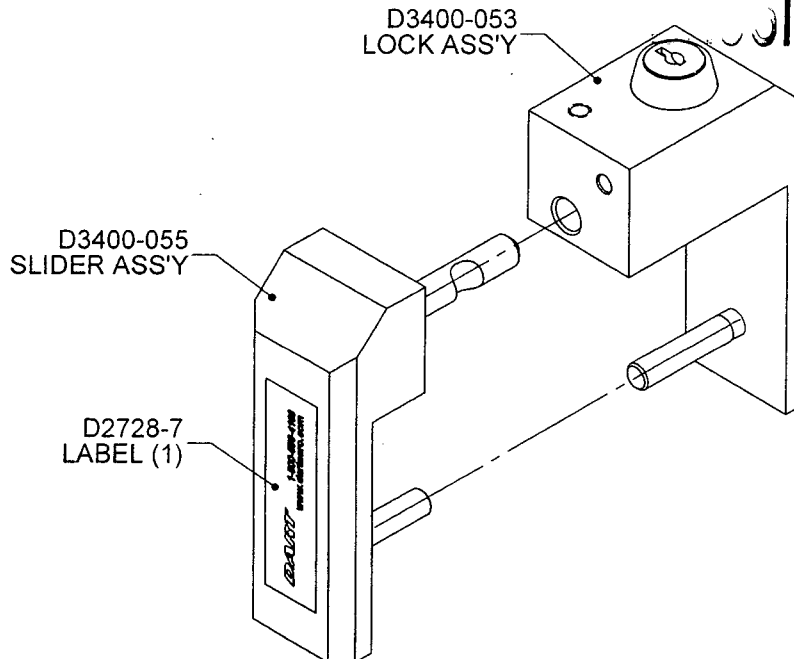
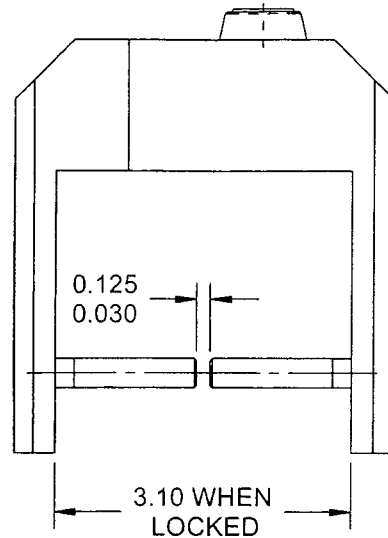
D3371-041 Key Numbers	D3400-041 Key Numbers
	C420A

Rev	Date	Change	Revised By	Approved
A	05.03.07	New Issue	KJ/RF	JA

DESIGN 	DRAWN BY 	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. <b>D3400</b>	REV. A SHEET 1 OF 6
DATE <b>05.02.23</b>		TITLE <b>COLLECTIVE LOCK</b>	SCALE 1:2
A	05.02.23	NEW ISSUE	



**COLLECTIVE LOCK SHOWN  
LOCKED WITH KEYS**



**D3400-051 AS355 COLLECTIVE LOCK ASS'Y**

**NOTES:**

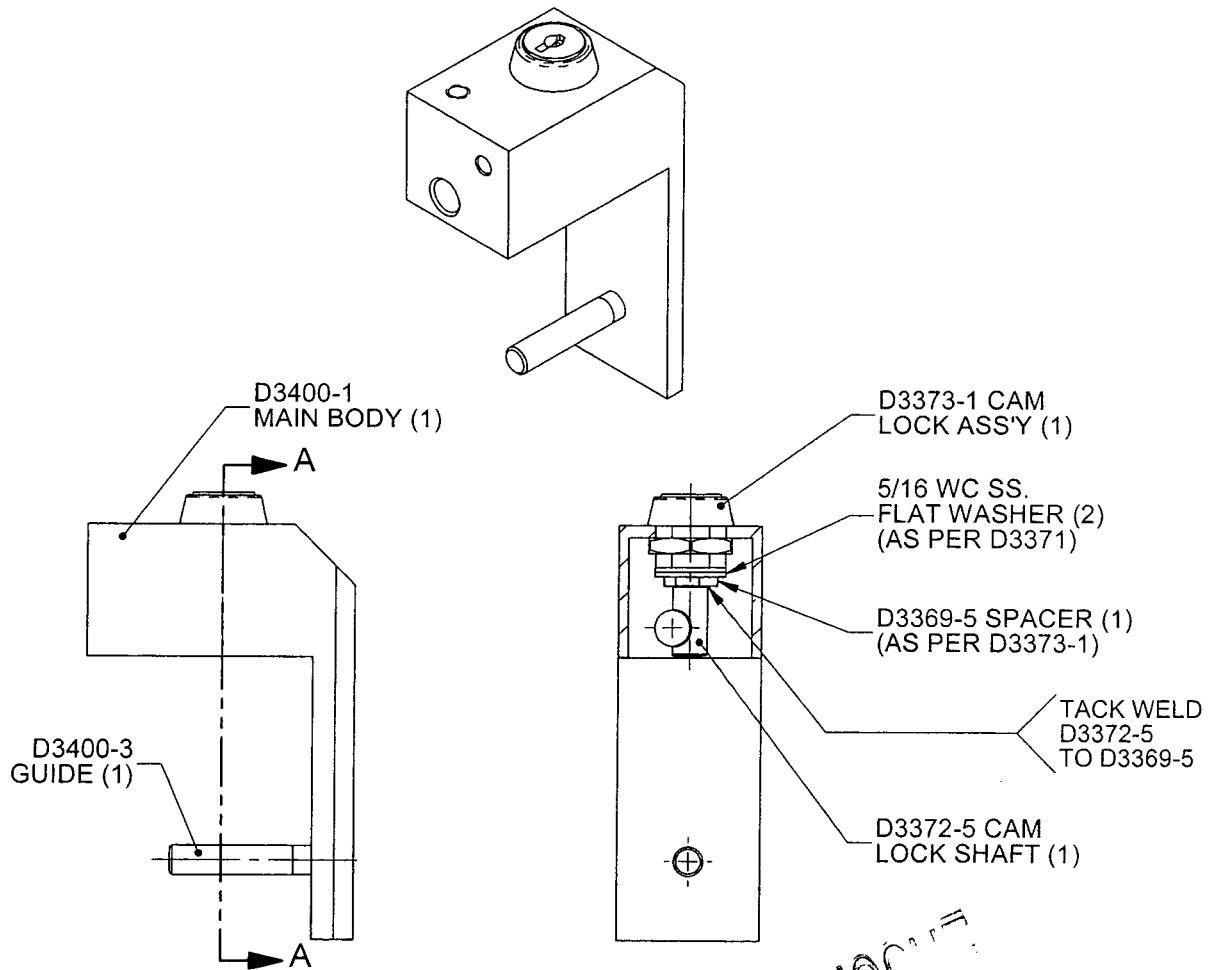
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES

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DATE <b>05.02.23</b>		TITLE <b>COLLECTIVE LOCK</b>	SCALE 1:2



SECTION A-A

**D3400-053 LOCK ASS'Y**

**NOTES:**

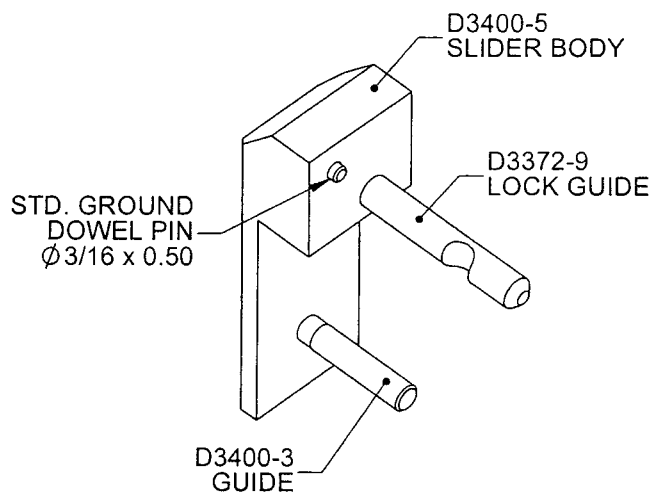
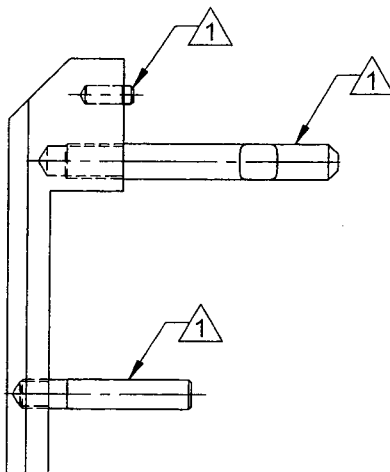
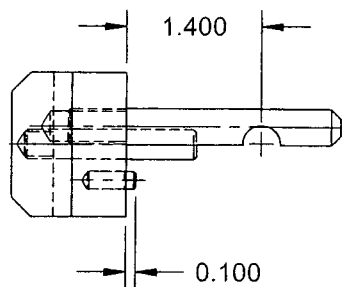
1) WELD PER DART QSI 004

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DATE <b>05.02.23</b>		TITLE <b>COLLECTIVE LOCK</b>	SCALE 1:2



**FOR PRODUCTION ISSUE**

### D3400-055 SLIDER ASS'Y

#### NOTES:

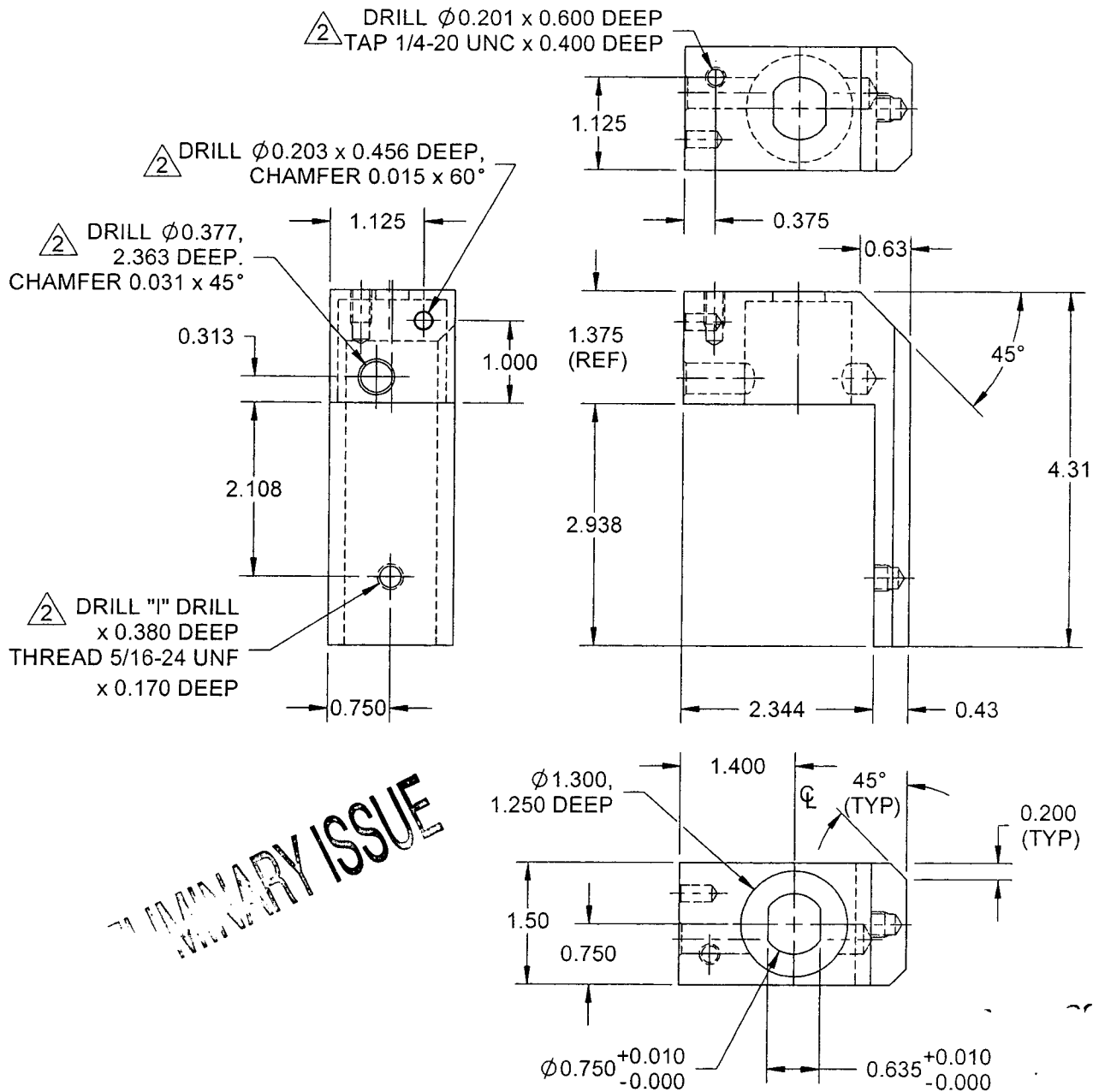
- 1) COVER DOWEL PIN, D3400-3 AND D3372-9 PRIOR PAINTING
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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CHECKED	APPROVED	DRAWING NO. <b>D3400</b>	REV. A SHEET 4 OF 6
DATE <b>05.02.23</b>		TITLE <b>COLLECTIVE LOCK</b>	SCALE 1:2



**PROBABLE ISSUE**

### **D3400-1 MAIN BODY**

#### **NOTES:**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)  
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

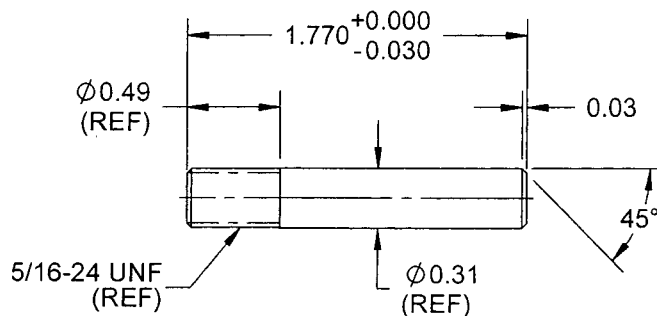
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CHECKED	APPROVED	DRAWING NO. <b>D3400</b>	REV. B SHEET 5 OF 6
DATE <b>05.02.23</b>		TITLE <b>COLLECTIVE LOCK</b>	SCALE 1:1

## SPECIFICATION CONTROL DRAWING



**PRELIMINARY ISSUE**

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### D3400-3 GUIDE

#### NOTES:

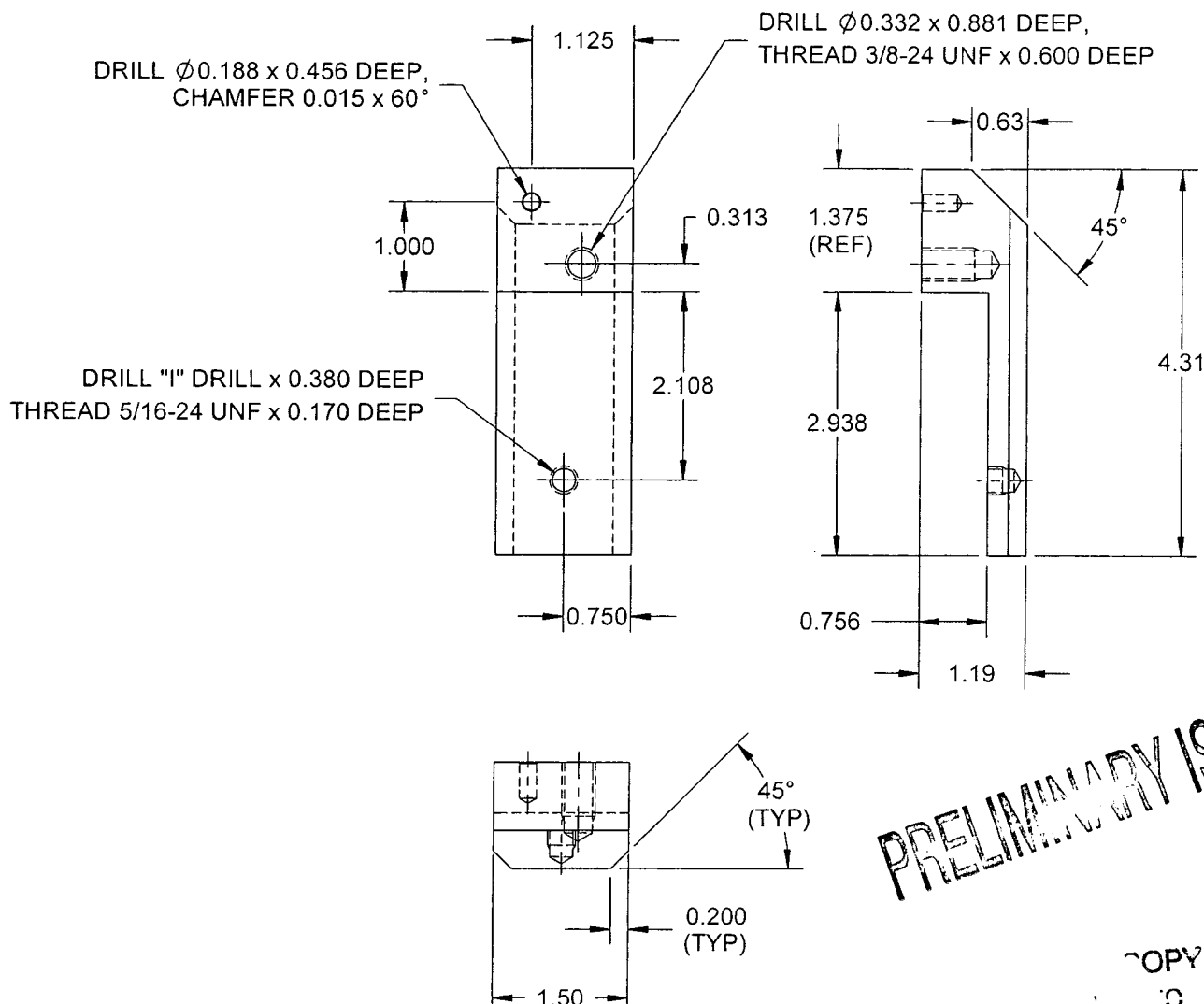
- 1) MATERIAL: AN5-17A BOLT MODIFIED AS SHOWN.
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

**WORK ORDER**  
**NO. 22627**

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DATE <b>05.02.23</b>		TITLE <b>COLLECTIVE LOCK</b>	SCALE 1:2



### D3400-5 SLIDER BODY

#### NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)  
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

**PRELIMINARY ISSUE**

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MOVE THE COLLECTIVE  
CONTROL STICK PRIOR  
TO THE INSTALLATION OF  
D3372-051 OR D3400-051  
COLLECTIVE LOCK  
ASSEMBLY

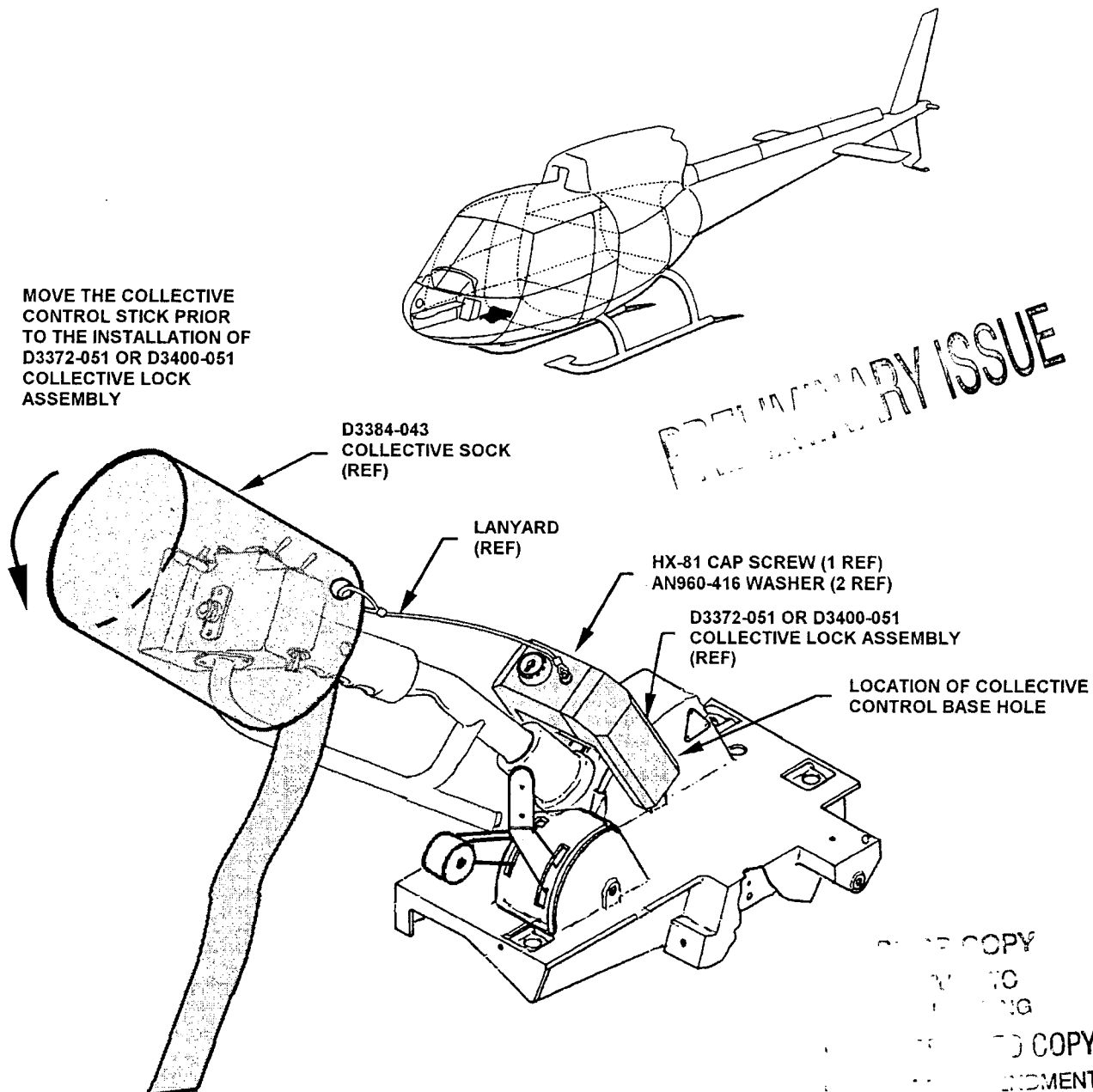


Figure 2– Location of D3372-041 or D3400-041 Collective Disabling Kit

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Revision: B  
Date: 05.02.24

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